

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016051**Date Inspected:** 03-Aug-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG components.**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Mr. Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS)

Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

OBG Trial Assembly Yard:

This QA Inspector observed the following work in progress:

OBG Seg 9CW and Seg 9DW:

The Shielded Metal Arc Welding (SMAW) process on weld joint no: OBW9C-002. The welder's were identified as 066038, 067942 and 067765 and were observed welding in the 4G position. ZPMC Quality Control (QC) was identified as Zhou Peng. The welding variables recorded by QC appeared to comply with WPS:

B-P-2214-B-U2-FCM-1. See attached photo for further details.

OBG Seg 9CE:

Repair welding on weld joint no: CA066-005. Welding process was identified as SMAW. The welder was identified as 048659 and was observed welding in the 2G position. ZPMC QC was identified as An Qiang Xiang. The welding variables recorded by QC appeared to comply with WPS: 345-SMAW-2G(2F)-FCM-repair-1. Repair

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welding was done as per Critical Welding Report (CWR): B-CWR-1738 Rev-1.

OBG Seg 9DE:

Repair welding on weld joint no: Seg056B-043. Welding process was identified as SMAW. The welder was identified as 045567 and was observed welding in the 3G position. ZPMC QC was identified as An Qiang Xiang. The welding variables recorded by QC appeared to comply with WPS: 345-SMAW-3G(3F)-Repair-1. Repair welding was done as per Welding Repair Report (WRR): B-WR-14120 Rev-1.

Repair welding on weld joint no: Seg056B-066. Welding process was identified as SMAW. The welder was identified as 053753 and was observed welding in the 2G position. ZPMC QC was identified as An Qiang Xiang. The welding variables recorded by QC appeared to comply with WPS: 345-SMAW-2G(2F)-FCM-Repair-1. Repair welding was done as per WRR: B-WR-14137 Rev-0.

Cross Beam 14 (CB14):

Notification No: 006328.

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC QC personnel. This QA Inspector generated a UT report on this date. The members are identified as OBG component – CB14. The weld designations reviewed are as follows:

- 1) CB202G-041-067, 069, 081 and 149.
- 2) CB202G-042-149 and 081.
- 3) CB202G-043-059, 085, 087, 135 and 137.
- 4) CB202G-044-085, 087 and 135.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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### Summary of Conversations:

No significant conversations were reported on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372., who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Wadkar,Sailesh
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Quality Assurance Inspector
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<b>Reviewed By:</b>	Peterson,Art
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QA Reviewer
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